

Date: Tuesday, 12/12/2006 8:57:05 AM
User: Jean-Luc Menard

Process Sheet

412-664-245

| | | | |
|-----------------------|--------------------------------|------------------|------------------------------|
| Customer | : CC-DAR01 Dart Aerospace Ltd. | Drawing Name | : INITIAL PROTOTYPE TEMPLATE |
| Job Number | : 00085A | | |
| Estimate Number | : 10068 | | |
| P.O. Number | : N/A | Part Number | : INITIAL PROTOTYPE |
| This Issue | : 12/12/2006 S.O. No. : N/A | Drawing Number | : N/A |
| Prsht Rev. | : NC | Project Number | : LG0006 |
| First Issue | : 11/9/2006 Type : R&D GENERAL | Drawing Revision | : N/A |
| Previous Run | : 00084A | Material | : N/A |
| Written By | : <u>JS 06.12.12</u> | Due Date | : 10/10/2006 Qty: 1 Um: Each |
| Checked & Approved By | : _____ | | |
| Comment | : Project #: _____ | | |
| | : Description: _____ | | |

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

1 - Material 1 D6009-129 Batch: B25668 (2)

2 - TURN AS PER DWG: (rev.A)

BG 06.12.13 (2)

3 - QC2

BG 06.12.13 (2)

4 - QCB (rev.A)

MB 06/12/20 (A)

5 - Bend AS per Dwg.

DP 6-12-19 (1A)

6 - install Support as per Dwg

A 06.12.20 (1)

7 - install Abrasion Strips +
chaffing shields as per Dwg

BT 06-12-20 (1A)

5A - CHEMICAL CONVERSION COAT PER DWT Q51 Q5 4.1 DP 6-12-20

2.0

PG

PURCHASING



Comment: PURCHASING

Attached certificate of conformity for raw material and subcomponents use for this w/o

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00085A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

PACKAGING 1

PACKAGING RESOURCE #1



N/A

Comment: PACKAGING

Identify "FOR ENGINEERING USE ONLY" and distribute to engineering.

4.0

ENGINEERING 1

ENGINEERING RESOURCE #1



Comment: ENGINEERING RESOURCE #1

Approval of project manager

JP 06.12.20

5.0

QC21

FINAL INSPECTION/W/O RELEASE



06.12.20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



PRELIMINARY ISSUE

| | | | |
|---------------------|-----------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D412-664-245 | REV. C SHEET 1 OF 3 |
| DATE 06.12.01 | | TITLE CROSSTUBE ASS'Y (412CF L-N AFT) NTS | |
| A | 06.12.01 | NEW ISSUE | |

PARTS LIST:

| Qty | Part Number | Description |
|-----|----------------|---|
| X | D412-664-245 | CROSSTUBE ASSEMBLY (412CF LOW-NARROW AFT) |
| 1 | D6009-129 | CROSSTUBE |
| 2 | D2732-058 | RUBBER CUSHION |
| 1 | D2896-1 | SUPPORT |
| 2 | D2856-600-1009 | ABRASION STRIP |
| 4 | MS21920-28 | CLAMP |
| 2 | MS21920-32 | CLAMP |
| 2 | D3189-1 | CHAFING SHIELD |
| A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

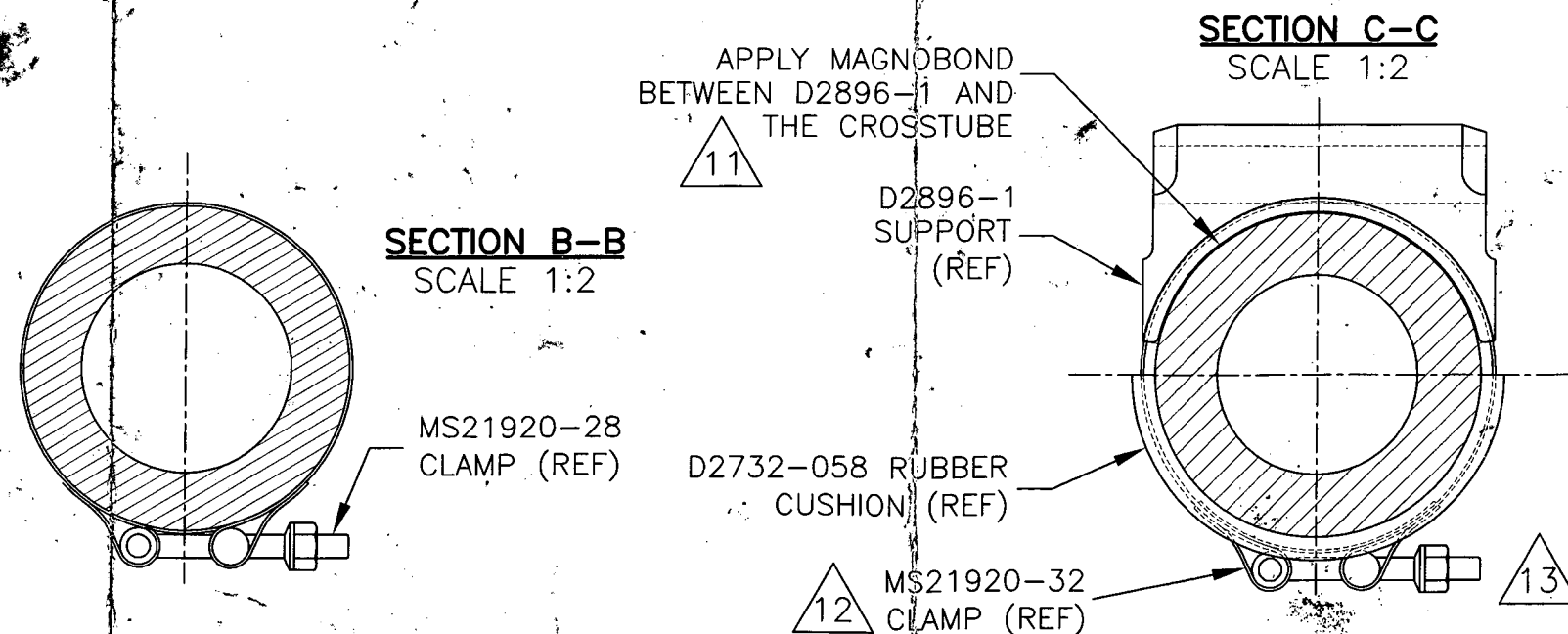
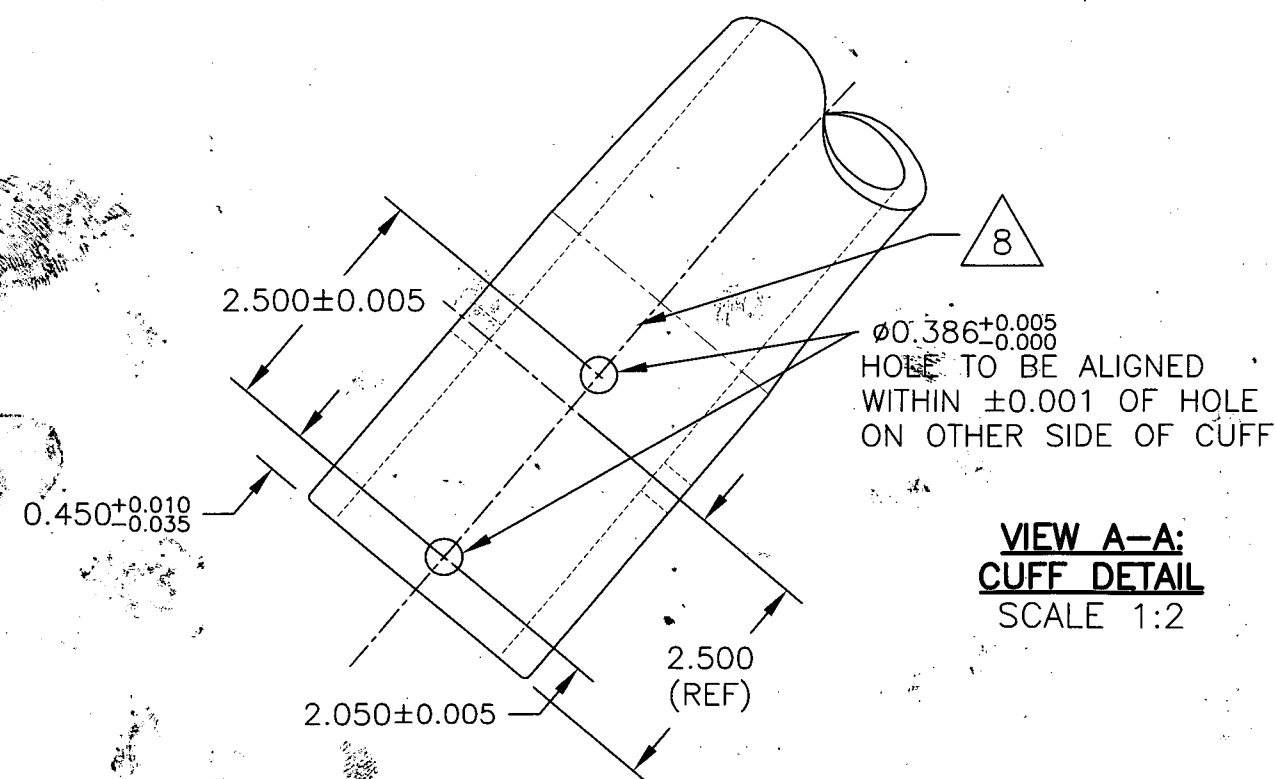
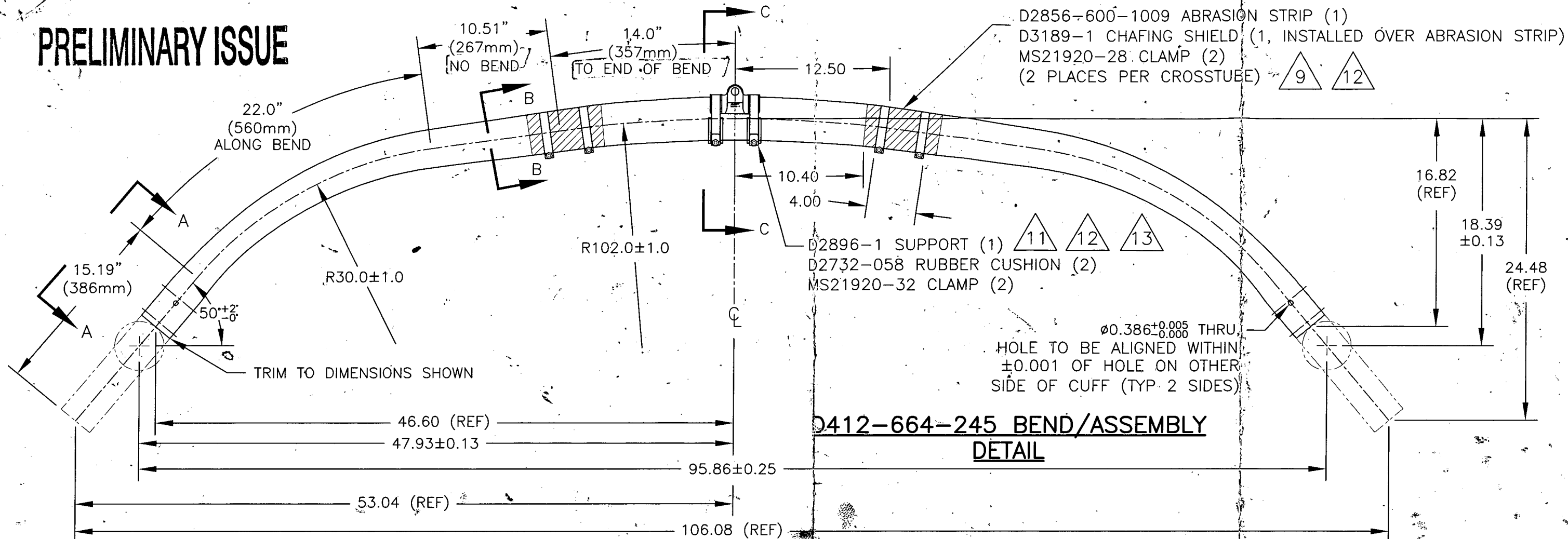
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 123.59±0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR PACKAGING.
- 12) INSTALL MS21920-32 CLAMPS WITH D2732-058 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB.

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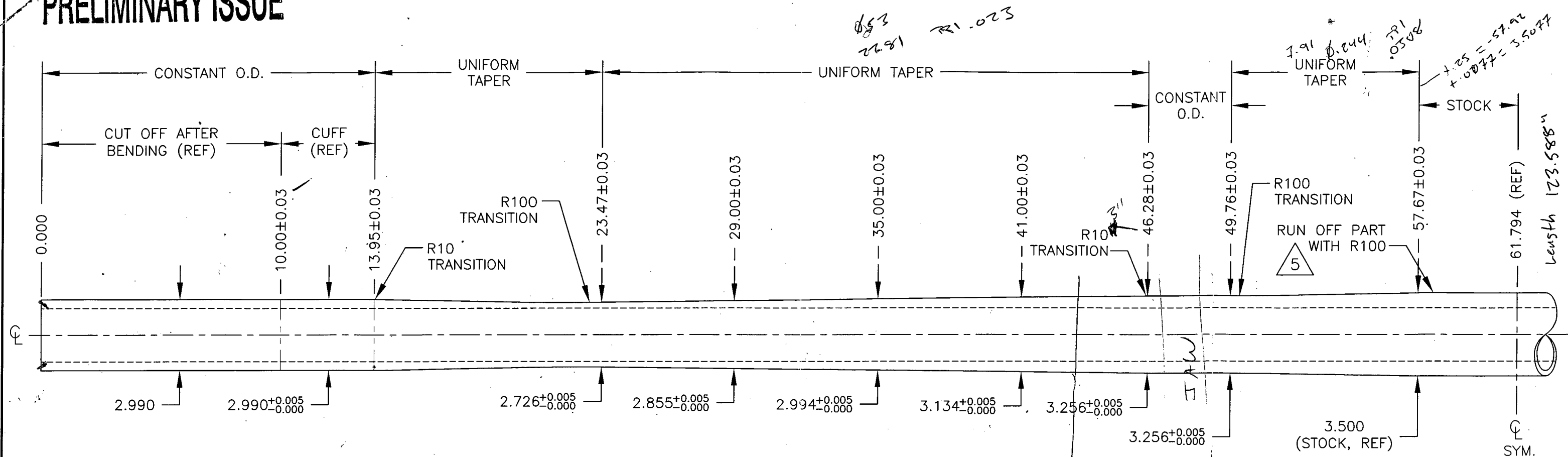
10/1/57

PRELIMINARY ISSUE



| | | | | |
|--|---------------------|-----------------------|--|--|
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| | CHECKED | APPROVED | | |
| | DATE 06.12.01 | | TITLE CROSSTUBE (412CF LOW-NARROW AFT)1:8 | SCALE |

PRELIMINARY ISSUE



D412-664-245 MACHINING DETAIL

step 2 start x 3.1847 z 43.38

step 1 fm x 3.187 z 43.28

1st step R 1 pass

2nd step - straight passes to 2.99 + 4.125

- Rough fin contour

chamber

R +.02

SF +.01

Ø .125" = 5.435" L @ .023 TR1

| | | |
|--------|---------|-----------|
| STEP 1 | x 3.375 | z -52.235 |
| 2 | x 3.250 | z -46.800 |
| 3 | x 3.125 | z -41.365 |
| 4 | x 3.000 | z -35.93 |

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DESIGN

qp

DRAWN BY

qp

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.
D412-664-245

REV. A

SHEET 3 OF 3

DATE

06.12.01

TITLE

CROSSTUBE (412CF LOW-NARROW AFT) 1:4

SCALE

| | | | |
|---|--|---------------------|-------------------------------------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: Crosstube Assembly (AS350/355 High-Aft) | | Part Number: | D412-664-245 D350-748-241 |
| Inspection Dwg: D350-748-241 Rev: G A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|------------------|---------------------|---------------------|--------|-------------------------|----------|
| SIDE A | 2.990 | +0.005 -0.000 | 2.992 | — | | |
| | 2.726 | " | 2.731 | — | | |
| | 2.855 | " | 2.859 | — | | |
| | 2.994 | " | 2.996 | — | | |
| | 3.134 | " | 3.136 | — | | |
| | 3.256 | " | 3.260 | — | | |
| | 3.256 | " | 3.260 | — | | |
| | 3.500 | STOCK REF | 3.487 | — | | |
| | | | from 3.487 to 3.498 | | | |
| | | | | | | |
| SIDE B | 2.990 | +0.005 -0.000 | 2.993 | — | | |
| | 2.726 | " | 2.731 | — | | |
| | 2.855 | " | 2.860 | — | | |
| | 2.994 | " | 2.997 | — | | |
| | 3.134 | " | 3.137 | — | | |
| | 3.256 | " | 3.231 | — | | |
| | 3.256 | " | 3.261 | — | | |
| | 3.256 | " | 3.261 | — | | |
| | 123.588 | ±.02 | 123.588 | — | | |
| | | | | | | |










| | | | | | |
|---------------------|----------|--------------------|----------|----------------------------|----------|
| Measured by: | BC | Audited by: | MS | Prototype Approval: | N/A |
| Date: | 06.12.13 | Date: | 06/12/14 | Date: | 06/12/14 |

| | | | | |
|------------|-------------|------------------------------|-------------------|-----------------|
| Rev | Date | Change | Revised by | Approved |
| A | | New Issue (P/O D350-748-201) | KJ/JLM | |

Aluminum plates

Date: Monday, 1/30/2006 3:43:52 PM
 User: Kim Johnston

Process Sheet

| | | |
|---|--|----------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : CROSSTUBE EXTRUSION (412 AFT) | REFERENCE ONLY |
| Job Number : 25668 | Part Number : D6009129 | |
| Estimate Number : 10030 | Drawing Number : D6009 REV A | |
| P.O. Number : N/A | Project Number : N/A | |
| This Issue : 1/30/2006 S.O. No. : N/A | Drawing Revision : A | |
| Prsht Rev. : NC | Material : N/A | |
| First Issue : N/A Type : LANDING GEAR | Due Date : 6/1/2006 | Qty: 20 Um: Each |
| Previous Run : N/A | | |
| Written By : <i>SEE COMMENT BELOW</i> | | |
| Checked & Approved By : <i>06.01.30 W</i> | | |
| Comment : Est Rev:A 04.08.17 New Issue SM | | |
| Additional Product | | |
| Job Number:  | | |
| Seq. #: | Machine Or Operation: | Description : |
| 1.0 | PG | PURCHASING |
|   | | |
| Comment: PURCHASING Issue P/O: <i>00000505</i> <i>06102102</i> a) Order as per Dwg D6009 b) Material: 3.500 x 0.625 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube c) Minimum ultimate tensile strength = 77 ksi d) Minimum tensile yield strength = 66 ksi e) Tolerance are per ASTM B210 (see details on Dwg D6009) f) Material certification required | | |
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|   | | |
| Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <i>06128106</i> <i>(22)</i> | | |
| 3.0 | QC6 | DIMENSIONAL CHECK |
|   | | |
| Comment: DIMENSIONAL CHECK Ensure Material certification comply to Dwg D <i>MB 06/06/30</i> <i>22</i> | | |
| 4.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|   | | |
| Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>N/A</i> | | |

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSTUBE EXTRUSION (412 AFT)

Job Number: 25668

Part Number: D6009129

Job Number:



REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ml 06/06/30

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/04 (22)
W 06/07/04

Job Completion





ALUnna

Abnahmeprüfzeugnis 3.1 - EN 10204:2004**Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004****Kunde:**

Dart Aerospace Ltd.

Client:

1270 Aberdeen Street
K6A1K7- Hawkesbury, ON Canada**Produkt:**

Rohre nahtlos gepresst

Product / Produit:

Tubes seamless extruded

Spezifikation:

-; AMS - QQ - A - 200/11E; -; -; -

Specification:

Werkstoff:

7075

Alloy/Alliage:

Abmessung

3,500 INCH x 2,250 INCH x 0,625 INCH x 129,000 INCH

Size / Dimension

D6009-129 3.500 X 0.625 X 129

KennzeichnungALUnna-Cert No.363/06-7075-T6511-Cast No.80117-QQA-200/11E-3.500" OD X 0.625"Wall-Heat No.421/04-
Lot17486/9-1-P.O.00000505

Marking/Marquage:

Lieferung

Delivered Material / Matériel délivré:

pcs.

lbs

22

1629

Zustand:
Temper/Etat

T 6511

REFERENCE ONLY**1. Chemische Analyse****Chemical Analysis / analyse chimique**

| | Si | Fe | Cu | Mn | Mg | Cr | Zn | Ti | Pb | Zr | Bi | Sn | Ni |
|---------------|------|------|------|------|------|------|------|------|-------|----|----|----|----|
| Charge/ min. | | | 1,2 | | 2,1 | 0,18 | 5,1 | | | | | | |
| Cast No. max. | 0,40 | 0,50 | 2,0 | 0,30 | 2,9 | 0,28 | 6,1 | 0,20 | | | | | |
| 80117 | 0,07 | 0,15 | 1,53 | 0,04 | 2,48 | 0,19 | 5,87 | 0,04 | <0,05 | | | | |

Elements without indication < 0,01 %

2. Mechanische Eigenschaften**Mechanical Properties / Valeurs Mécaniques**

| Anforderungen Requirements | tensile (Rm) ksi | yield (Rp0,2) ksi | elongation 2" % | elongation A % | Hardness HB | Heat No. |
|-------------------------------|---------------------|----------------------|--------------------|-------------------|----------------|------------------|
| min. max. | 77,0 | 66,0 | | | | |
| 1 | 87,580 | 80,910 | 11,5 | 11,5 | 179 | 421/04 - 22 pcs. |
| 2 | 87,145 | 80,330 | 10,5 | 10,5 | 170 | |
| 3 | 87,000 | 79,895 | 10,5 | 10,5 | 166 | |
| 4 | 87,290 | 80,475 | 10,0 | 10,0 | 180 | |

**Ergebnis der
Prüfungen:**

Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

Test results:

We confirm that the delivery has been tested and applies to the agreements made on receipt of the order

Resultats:

Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

KroosD

Certified acc. to DIN EN ISO 9001:2000, valid until 2006-03-09
Certificate No.: 001959 QM

ALUnna

for confirmation

17486

page: 5
date: 3.03.2006
customer: 40980

Surface Finish max. RMS 25
Tolerances per ASTM B210 / drawing D6006
Tubes protected with corrosion protective oil
Tubes line marked
Packing: seaworthy wooden cases

| item | quantity | unitprice | USD | unit value | USD | delivery |
|------|----------|-----------|--------|------------|----------|---------------|
| 008 | 12,000 | PC | 678,42 | PC | 8.141,04 | June 22, 2006 |

AWU article: 16539 / Tariff no. 76082091
Customer article: D6008-180 3.250 X 0.438 X 180
product: TUBES / seamless extruded / EN AW-7075 / round
condition: T 6511 / AMS-QQ-A-200/11E

| | | | |
|------------------|-------------------|--------|--------|
| outer diameter: | 3,250 INCH Tol. | +0,016 | -0,016 |
| tol. for mean OD | | +0,008 | -0,008 |
| inner diameter: | 2,374 INCH | | |
| wall thickness: | 0,438 INCH Tol. | +0,043 | -0,043 |
| fixed length | 180,000 INCH Tol. | +0,125 | |

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455
straightness 0,01 INCH / 1 FEET / RMS outer 25
tol. on quantity +10 % -10 %
3.250" OD 0.438" Wall, 180" lengths
Part Number D6008-180 crosstube
Surface Finish max. RMS 25
Tolerances per ASTM B210 / drawing D6008
Tubes protected with corrosion protective oil
Tubes line marked
Packing: seaworthy wooden cases

| item | quantity | unitprice | USD | unit value | USD | delivery |
|------|----------|-----------|--------|------------|-----------|---------------|
| 009 | 20,000 | PC | 790,18 | PC | 15.803,60 | June 15, 2006 |

AWU article: 17956 / Tariff no. 76082091
Customer article: D6009-129 3.500 X 0.625 X 129
product: TUBES / seamless extruded / EN AW-7075 / round
condition: T 6511 / AMS-QQ-A-200/11E

| | | | |
|--------------------|-------------------|--------|--------|
| outer diameter: | 3,500 INCH Tol. | +0,016 | -0,016 |
| inner diameter: | 2,250 INCH | | |
| wall thickness: | 0,625 INCH Tol. | +0,063 | -0,063 |
| tol. for mean wall | | +0,020 | -0,020 |
| fixed length | 129,000 INCH Tol. | +0,188 | |

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455
straightness 0,01 INCH / 1 FEET / RMS outer 25
tol. on quantity +10 % -10 %
3.500" OD 0.625" Wall, 129" lengths

er confirmation

17486

page: 5
date: 3.03.2006
customer: 40980

Surface Finish max. RMS 25
Tolerances per ASTM B210 / drawing D6006
Tubes protected with corrosion protective oil
Tubes line marked
Packing: seaworthy wooden cases

| item | quantity | unitprice | USD | unit value | USD | delivery |
|------|----------|-----------|--------|------------|----------|---------------|
| 008 | 12,000 | PC | 678,42 | PC | 8.141,04 | June 22, 2006 |

AWU article: 16539 / Tariff no. 76082091
Customer article: D6008-180 3.250 X 0.438 X 180
product: TUBES / seamless extruded / EN AW-7075 / round
condition: T 6511 / AMS-QQ-A-200/11E

| | | | |
|------------------|-------------------|--------|--------|
| outer diameter: | 3,250 INCH Tol. | +0,016 | -0,016 |
| tol. for mean OD | | +0,008 | -0,008 |
| inner diameter: | 2,374 INCH | | |
| wall thickness: | 0,438 INCH Tol. | +0,043 | -0,043 |
| fixed length | 180,000 INCH Tol. | +0,125 | |

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455
straightness 0,01 INCH / 1 FEET / RMS outer 25
tol. on quantity +10 % -10 %
3.250" OD 0.438" Wall, 180" lengths
Part Number D6008-180 crosstube
Surface Finish max. RMS 25
Tolerances per ASTM B210 / drawing D6008
Tubes protected with corrosion protective oil
Tubes line marked
Packing: seaworthy wooden cases

| item | quantity | unitprice | USD | unit value | USD | delivery |
|------|----------|-----------|--------|------------|-----------|---------------|
| 009 | 20,000 | PC | 790,18 | PC | 15.803,60 | June 15, 2006 |

AWU article: 17956 / Tariff no. 76082091
Customer article: D6009-129 3.500 X 0.625 X 129
product: TUBES / seamless extruded / EN AW-7075 / round
condition: T 6511 / AMS-QQ-A-200/11E

| | | | |
|--------------------|-------------------|--------|--------|
| outer diameter: | 3,500 INCH Tol. | +0,016 | -0,016 |
| inner diameter: | 2,250 INCH | | |
| wall thickness: | 0,625 INCH Tol. | +0,063 | -0,063 |
| tol. for mean wall | | +0,020 | -0,020 |
| fixed length | 129,000 INCH Tol. | +0,188 | |

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455
straightness 0,01 INCH / 1 FEET / RMS outer 25
tol. on quantity +10 % -10 %
3.500" OD 0.625" Wall, 129" lengths



ALUnna

for confirmation

17486

page: 6
date: 3.03.2006
customer 40980

Part Number D6009-129 crosstube
Surface Finish max. RMS 25
Tolerances per ASTM B210
Straightness 0.010" deviation /12" length
Outside surface: max. defects up to 0.005" (longitudinally)
Min. ultimate tensile strength 77 ksi
Min. yield strength 66 ksi
Tubes protected with corrosion protective oil
Tubes line marked
Packing list, Inspection certificate
Packing: seaworthy wooden cases
terms of delivery: DDP (Delivered, Duty, Paid)
Terms of payment: 30 days after date of delivery

delivery address:
Main Finished Goods Location
Dart Aerospace Ltd.
1270 Aberdeen Street
CDN Hawkesbury, ONT, K6A1K7

delivery note

25234

page: 5
date: 29.05.2006
customer: 40980

| item | quantity | unit | net kgs |
|------|----------|------|---------|
|------|----------|------|---------|

| | | | |
|-----|--------|----|--|
| 008 | 13,000 | PC | |
|-----|--------|----|--|

AWU article: 16539 / Tariff no. 76082091

Customer article: D6008-180 3.250 X 0.438 X 180

product: TUBES / seamless extruded / EN AW-7075 / round

condition: T 6511 / AMS-QQ-A-200/11E

| | | | |
|-----------------|-------------------|--------|--------|
| outer diameter: | 3,250 INCH Tol. | +0,016 | -0,016 |
| tol.for mean OD | | +0,008 | -0,008 |
| inner diameter: | 2,374 INCH | | |
| wall thickness: | 0,438 INCH Tol. | +0,043 | -0,043 |
| fixed length | 180,000 INCH Tol. | +0,125 | |

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455

straightness 0,01 INCH / 1 FEET / RMS outer 25

tol. on quantity +10 % -10 %

3.250" OD 0.438" Wall, 180" lengths

Part Number D6008-180 crosstube

Surface Finish max. RMS 25

Tolerances per ASTM B210 / drawing D6008

Tubes protected with corrosion protective oil

Tubes line marked

Packing: seaworthy wooden cases

number of packages: 1

number of pieces: 13

| item | quantity | unit | net kgs |
|------|----------|------|---------|
|------|----------|------|---------|

| | | | |
|-----|--------|----|--|
| 009 | 22,000 | PC | |
|-----|--------|----|--|

AWU article: 17956 / Tariff no. 76082091

Customer article: D6009-129 3.500 X 0.625 X 129

product: TUBES / seamless extruded / EN AW-7075 / round

condition: T 6511 / AMS-QQ-A-200/11E

| | | | |
|-------------------|-------------------|--------|--------|
| outer diameter: | 3,500 INCH Tol. | +0,016 | -0,016 |
| inner diameter: | 2,250 INCH | | |
| wall thickness: | 0,625 INCH Tol. | +0,063 | -0,063 |
| tol.for mean wall | | +0,020 | -0,020 |
| fixed length | 129,000 INCH Tol. | +0,188 | |

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455

straightness 0,01 INCH / 1 FEET / RMS outer 25

tol. on quantity +10 % -10 %

3.500" OD 0.625" Wall, 129" lengths

Part Number D6009-129 crosstube

Surface Finish max. RMS 25

Tolerances per ASTM B210

Straightness 0.010" deviation /12" length

Outside surface: max. defects up to 0.005" (longitudinally)

Min. ultimate tensile strength 77 ksi

Min. yield strength 66 ksi

Tubes protected with corrosion protective oil

Tubes line marked

Packing list, Inspection certificate

Packing: seaworthy wooden cases

delivery note

25234

page: 5
date: 29.05.2006
customer: 40980

| item | quantity | unit | net kgs |
|------|----------|------|---------|
|------|----------|------|---------|

| | | | |
|-----|--------|----|--|
| 008 | 13,000 | PC | |
|-----|--------|----|--|

AWU article: 16539 / Tariff no. 76082091

Customer article: D6008-180 3.250 X 0.438 X 180

product: TUBES / seamless extruded / EN AW-7075 / round

condition: T 6511 / AMS-QQ-A-200/11E

| | | | |
|-----------------|-------------------|--------|--------|
| outer diameter: | 3,250 INCH Tol. | +0,016 | -0,016 |
| tol.for mean OD | | +0,008 | -0,008 |
| inner diameter: | 2,374 INCH | | |
| wall thickness: | 0,438 INCH Tol. | +0,043 | -0,043 |
| fixed length | 180,000 INCH Tol. | +0,125 | |

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455

straightness 0,01 INCH / 1 FEET / RMS outer 25

tol. on quantity +10 % -10 %

3.250" OD 0.438" Wall, 180" lengths

Part Number D6008-180 crosstube

Surface Finish max. RMS 25

Tolerances per ASTM B210 / drawing D6008

Tubes protected with corrosion protective oil

Tubes line marked

Packing: seaworthy wooden cases

number of packages: 1

number of pieces: 13

| item | quantity | unit | net kgs |
|------|----------|------|---------|
|------|----------|------|---------|

| | | | |
|-----|--------|----|--|
| 009 | 22,000 | PC | |
|-----|--------|----|--|

AWU article: 17956 / Tariff no. 76082091

Customer article: D6009-129 3.500 X 0.625 X 129

product: TUBES / seamless extruded / EN AW-7075 / round

condition: T 6511 / AMS-QQ-A-200/11E

| | | | |
|-------------------|-------------------|--------|--------|
| outer diameter: | 3,500 INCH Tol. | +0,016 | -0,016 |
| inner diameter: | 2,250 INCH | | |
| wall thickness: | 0,625 INCH Tol. | +0,063 | -0,063 |
| tol.for mean wall | | +0,020 | -0,020 |
| fixed length | 129,000 INCH Tol. | +0,188 | |

test report acc. to EN 10204/3.1 / RM 531 / Rp0,2: 455

straightness 0,01 INCH / 1 FEET / RMS outer 25

tol. on quantity +10 % -10 %

3.500" OD 0.625" Wall, 129" lengths

Part Number D6009-129 crosstube

Surface Finish max. RMS 25

Tolerances per ASTM B210

Straightness 0.010" deviation /12" length

Outside surface: max. defects up to 0.005" (longitudinally)

Min. ultimate tensile strength 77 ksi

Min. yield strength 66 ksi

Tubes protected with corrosion protective oil

Tubes line marked

Packing list, Inspection certificate

Packing: seaworthy wooden cases

delivery note**25234**

page: 6
date: 29.05.2006
customer 40980

number of packages: 1
number of pieces: 22

Terms of payment: 30 days after date of delivery
terms of delivery: DDP (Delivered, Duty, Paid)

| | | | | |
|------------|-------|----------|-----|----------|
| weight: | gross | 4659,500 | net | 3579,000 |
| Packstücke | 9 | | | |

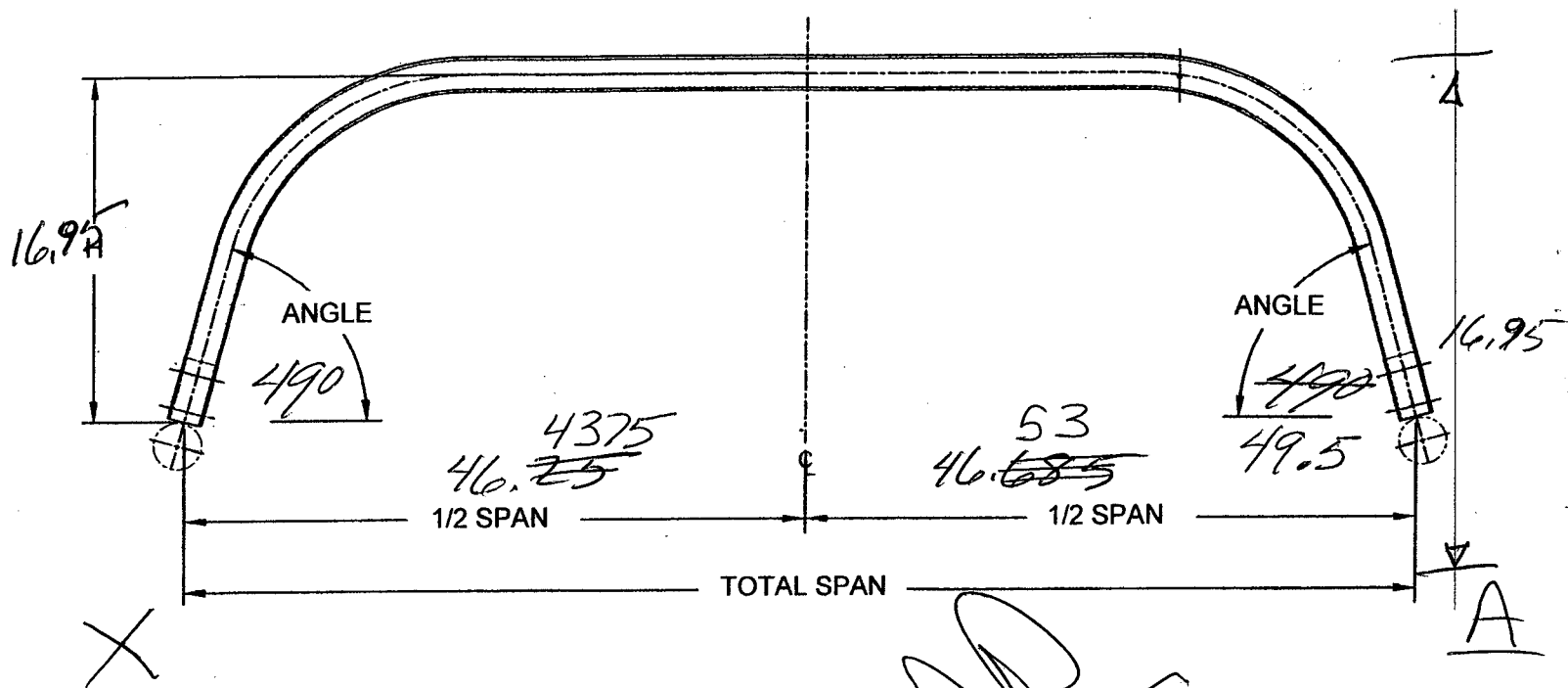
customer address:
DART AEROSPACE LTD.
1270 Aberdeen Street
CDN K6A 1K7 HAWKESBURY
ON

213 443

00085A

CFULA

Crosstube Bend Dimension Sheet



PART NUMBER: _____

BATCH NUMBER: _____

DRAWING: _____ REVISION: _____

H: _____

1/2 SPAN: _____

TOTAL SPAN: _____

ANGLE: _____

QC 15: _____

DATE: _____

QTY: _____

06.12.20

Job number: 00085A

Estimate number: 10068

STEP 6. INSTALL SUPPORTS PER DWG:

| | | | |
|--|---------|-----|--------------------|
| D2896-1 | SUPPORT | B/N | B27266 |
| MS21920-30 | CLAMP | B/N | M101568 |
| D21828-058 D2732-058 | CUSHION | B/N | 28042 2 |

STEP 7: INSTALL ABRASION STRIPS AND CHAFING SHIELD
AS PER DWG:

| | | | |
|----------------|----------------|-----|---------|
| D2856-600-1009 | ABRASION STRIP | B/N | B26650 |
| D3189-1 | CHAFING SHIELD | B/N | B27190 |
| MS21920-28 | CLAMP | B/N | M101684 |

IT 06.12.20

DEVIATIONS:

- MS21920-30 INSTEAD OF MS21920-32
- D21828 INSTEAD OF D2732-058
- No prime & paint
- ~~ANGLE OF BENDS ARE 49° & 49.5° INSTEAD OF $50^\circ \pm 2^\circ$~~
- One half span is under tolerance
(THIS IS CONSERVATIVE FOR DEFLECTION TEST)
- Qty(2) $\phi 0.386$ holes not drilled (for Bell saddles)
NOT REQ'D FOR THE TEST.

UK 4th 06.12.20

ACCEPTABLE
DEVIATIONS

FOR
TEST

06.12.20